

NCR-19-7749



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POSITIVE RECALL

EFFECTIVE 19/10/18 AUTH S.A.D.

RELEASED PD DATE 10/18/19

D1048**Job Sheet 200101**

Part No: D1048

Job Qty: 16 pcs

Part Name: Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock S.A.D.

Description:

Note: DWG REV A IPP: B 02.02.22 Re-format NG IPP Rev:C Now on Waterjet 06-12-06 JLM

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	16 pcs		10/4/19	0.17	0.43	Waterjet - Flow		
120	QC 8	16 pcs		10/4/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - 2 - B4B	16 pcs		10/4/19	0.00	0.48	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		

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Container No: S224160

Part: D1048

Job No: 200101

Serial No/Batch: S224160

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/18/19



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Will Need
Test Pit
Done by
Eng to continue
Please
see Eng

Test Pit
Done
Acceptable
SAP
19/11/19

140	Small Fab - Brake NC - B4B	16 pcs	10/4/19	0.25 0.46	Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	DAS 58 OCT 7 3 2019 9-89
					Small Fab - Brake - 3 - B4B	
150	QC 5	16 pcs	10/4/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS 40 OCT 2 4 2019 9-89
					QC 5 - 61	
					QC 5 - 81	
160	Powdercoat - 4 Black Sand - B4B	16 pcs	10/4/19	0.00 0.13	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	16 pcs	10/4/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	DAS 40 OCT 3 1 2019 9-89
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180	Packaging 3-1 - Stock - B4B	16 pcs	10/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	

Packaging 3 - 5 - B4B	
Packaging 3 - 6 - B4B	
Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B	

190 QC 21 - SA

16
pcs

10/4/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

D/S

21

8-00

NOV 05 2019

Part Op 100 - 1-Cut as per Dwg D1048 Prog Rev: A

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

140 - Form as per dwg using DT10143

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3), START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.2880 sf (.018 ea)	100-Waterjet - Flow - 1	52004142

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	0	493	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.750Inches $\pm$ 0.010	0.760 0.740	.753	
2	Clamp	2.175Inches $\pm$ 0.010	2.185 2.165	2.174	
3	Clamp	1.755Inches $\pm$ 0.010	1.765 1.745	1.756	
4	Clamp	0.375Inches $\pm$ 0.010	0.385 0.365		
5	Clamp	0.203Inches + 0.005 - 0.001	0.208 0.202	0.205 Diameter	

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Entered: LR Date: Nov 19/19



NCR No. 19-7741

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>200101</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>D1048</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐
Date: <u>19/11/5</u>	Sequence #: <u>180</u>		QTY Affected: <u>(1)</u>		MRB (QSI042)		
Description Work Order Deviation			Disposition			INSP 12 <u>19/11/5</u>	
The following dimension will be change <u>LeJas</u> <u>is</u> 2.125 → 2.175 1.705 → 1.755 Change required to mate ^{align} with mating part. Ref. PAR 15-419			Engineering will test fit the following parts. Acceptable. Test assembly of mirror showed proper alignment with bracket. No change to hole edge distance. <u>19/11/5</u>			Completed By <u>19/11/5</u>	
						Lead hand / Supervisor	
						QC / QA Coordinator <u>19-11-05</u>	
Root Cause		FAULT CATEGORY					
Operator ☐		☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong		
Manufacturing Process ☐		☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance		
Equip/Tooling ☐		☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing		
Handling/Presservation ☐		☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish		
Material ☐		☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Product Improvement ☒		☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread		
Process Improvement ☐		☐ Mislabeled	☒ Fit/Function	☐ Off-set/Set-up			
Human Factors ☐		Other/Details:					